

Work Order ID 107444

September-24-13 11:50:06 AM

107444

Page 1

Item ID: D135-751-011

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube (Fits LH or RH)

Start Date: 9/24/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/25/13 Req'd Qty: 1.00 ***1***

Customer: CALOG01

Reference: RMA RA111610

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3507	Rev C

100 0.00

100

QC

Quality Control

Memo

INSPECT RA111610
D135-751-011 B86226

0.00

MLJ 13-12-19

110 0.00

110

HandFinish

Hand Finishing

Memo

-REMOVE AFT CAP AND ALL SIKAFLEX

-BUFF OUT DAMAGE TO BLEND IN

-TOUCH UP WITH ALODINE

0.00

1 0 0 A
13-12-19

PART		TO APPROVAL 4-09-89	
D135-751-011		CHG001	
Skidtube		SR01709SE	
B86226			
EC135 P1/P2/P2+T1/T2/T2+			

MADE IN CANADA 027292

September-24-13 11:50:06 AM

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube (Fits LH or RH)

Start Date: 9/24/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/25/13 Req'd Qty: 1.00 * 1 *

Customer: CALOG01

Reference: RMA RA111610

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Powdercoat

Memo

0.00

Powder Coating

TOUCH UP POWDER COAT A/R

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

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N900040100

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Required Date: 9/25/13 Req'd Qty: 1.00 ***1***

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Reference: RMA RA111610

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	RE-INSTALL AFT CAP SIKAFLEX B								
	<i>N/A</i>								
	<i>mbd 13-12-19</i>								
160		0.00							
160									
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT IS IN BOX								
			DAS						
			6						
			9-89						
			<i>13/12/19</i>						
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									
			DAS						
			6						
			9-89						
			<i>13/12/19</i>						

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Cust Item ID:

Required Date: 9/25/13 Req'd Qty: 1.00 ***1***

Customer: CALOG01

Reference: RMA RA111610

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>071</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	RE-PACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14/1/13 SL14-01-1314-01-13

Picklist Print

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Page 1

Work Order ID: 107444

Parent Item: D135-751-011

Start Date: 9/24/13

Required Date: 9/25/13

Parent Item Name: Skidtube (Fits LH or RH)

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F 10.06.09 remove
 seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified
 by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D135-751-011 Skidtube (Fits LH or RH)		Manufactured	No				Each	3.0000		1			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	3	
87911	1	
98053	1	
98603	1	

99512

1

U 1702-19

RA 111610
D135-751-101 B99512
D135-751-011 B86226

Instructions for RA 111610 D135-751-011 B86226

- Skid tube was damaged in returning (see pictures)
- Tube needs re works
 - Remove aft cap and all excess sik-a-flex
 - Buff out damage to blend in
 - Touch up alodine is required
 - Preform a touch up powder coat
 - Re install aft cap with new sik-a-flex
- Kit complete
- Needs new labels and paper work
- Needs new Batch # for reworking

Time Estimate = 5 HOURS

Departments Required: Finishing & Packaging

Pictures Attached = YES

QTY INSPECTED = x1 D135-751-011 B86226

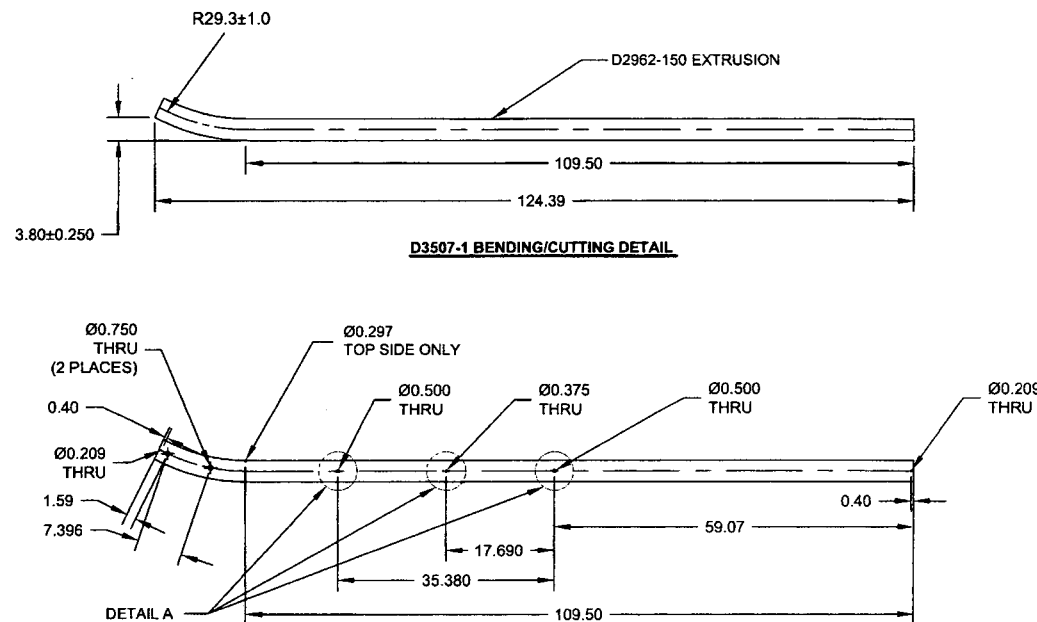
**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

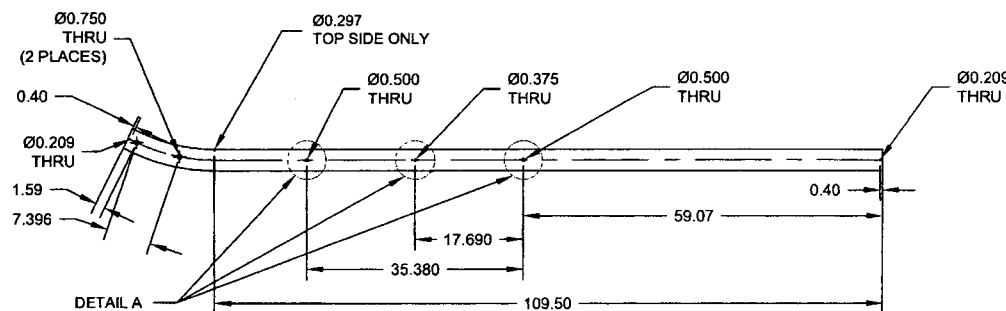
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

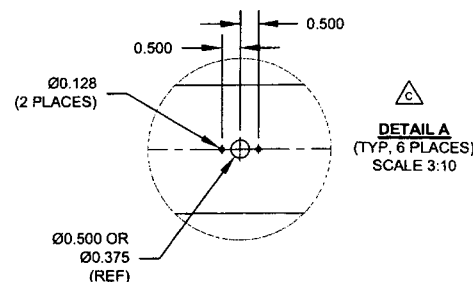
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JIC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3507 TITLE EC 135 SKIDTUBE SCALE NTS REV. C SHEET 1 OF 2 COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

Handwritten note:
w/o 107444

RELEASED
07.11.16

